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D350-591-121
Job Sheet 196994

Part No: D350-591-121

Job Qty: 4 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/26/19

Job Tracking No:

Due Date: 7/30/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG IIN-D350-591 REV H, D2351-041 REV E IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF IPP rev. F 06.02.23 added grinding EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Large Fab - Steps - 1	4 pcs	7/30/19	7/30/19	0.00	2.72	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	Skidtubes - Bend - 2 - B4B	4 pcs	7/30/19	7/30/19	0.38	1.17	Skidtubes - Bend - B4B		
122	QC 5	4 pcs	7/30/19	7/30/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Large Fab - Steps - 2 - B4B	4	7/30/19	7/30/19	0.00	2.72	Large Fab - 1 - B4B		

Plex 6/26/19 4:20 PM Dart.Guerin.Kimberley

	pcs					Large Fab - 10 - B4B	
						Large Fab - 2 - B4B	
						Large Fab - 3 - B4B	
						Large Fab - 4 - B4B	
						Large Fab - 5 - B4B	
						Large Fab - 6 - B4B	
						Large Fab - 7 - B4B	11
						Large Fab - 8 - B4B	
						Large Fab - 9 - B4B	
						Large Fab - 11 - B4B (Various)	
						QC 9 - 10	
150 QC 9	4 pcs	7/30/19	0.00	0.00		QC 9 - 18	DAS
						QC 9 - 24	24
						QC 9 - 43	9-89
						QC 9 - 50	
						QC 9 - 9	
						QC 5 - 10	
160 QC 5	4 pcs	7/30/19	0.00	0.00		QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	DAS
						QC 5 - 3	24
						QC 5 - 43	9-89
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
170 Handfinish - 1-1 Chemical-B4B	4 pcs	7/30/19	0.00	0.74		QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
180 QC 7	4 pcs	7/30/19	0.00	0.00			

				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
190 Large Fab - Steps - 3 - B4B	4 pcs	7/30/19	0.00 2.72	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
220 QC 10	4 pcs	7/30/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
230 QC 5	4 pcs	7/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	

DAS
24
9-89

JUL 2 4 2019

DAS
24
9-89

JUL 2 4 2019

CL

240 Handfinish - 1-2- Chemical-B4B	4 pcs	7/30/19	0.00 0.74	QC 5 - 9	
				QC 5 - 50	CL
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
250 Powdercoat - 1 White Gl(A)-B4B	4 pcs	7/30/19	0.00 0.65	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
260 Handfinish - 3-1- WingWalk-B4B	4 pcs	7/30/19	0.00 0.74	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
270 QC 3	4 pcs	7/30/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
280 Packaging 1-1 - Pick Kit -	4	7/30/19	0.00 0.00	Packaging 1 - 1 - B4B	

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B4B	pcs				Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	pc JUL 29 2019
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
290 QC 4	4 pcs	7/30/19	0.00	0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	DAS 75 9-89
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	JUL 30 2019
					QC 4 - 74	
					QC 4 - 75	
300 Packaging 3-1 - Stock - B4B	4 pcs	7/30/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	DAS 75 9-89
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	JUL 30 2019
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
305 DC - 1 - B4B	4	7/30/19	0.00 0.00	DC - 1 - B4B	DAG 21 9-22
	pcs			DC - 2 - B4B	
310 QC 21 - FG	4	7/30/19	0.00 0.00	QC 21 - FG - 21	DAS 21 9-22
	pcs			QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 110 - (Fabricate per Dwg) 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 2- Drill holes as per dwg using Descriptions: DT8230.

120 - (CNC Delta 100 Bender) Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041. Use DT8033 jig to make sure bend is good and fits the jig.

122 - (QC5- Inspect part completeness to step on W/O)

140 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033 A/RAluminum Rod _____ 3-Do not Grind Flush

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Chemical Conversion Coat per QSI005 4.1)

180 - (QC7-Inspect Chemical Conversion Coat)

190 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod _____ 3-Grind end plate flush.

220 - (QC10- Inspect visual per QSI004- ground welds)

230 - (QC5- Inspect part completeness to step on W/O)

240 - (Chemical Conversion Coat per QSI005 4.1)

250 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 11:25 OVEN TEMPERATURE: 300°

FINISH TIME: 11:05. M175457.

260 - (Wing Walk as per dwg QSI005 4.4 Batch _____)

270 - (QC3- Inspect Part Finish)

280 - (Pick Kit)

290 - (QC4- 100% Inspect kits for completeness)

300 - Identify and pack for shipping as per PPP D350-591-121 Location:FG039

305 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

310 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2 pcs (.5 ea)	110-Large Fab - Steps - 1	5160553
D2850-1	End Bracket	4 pcs (1 ea)	140-Large Fab - Steps - 2 - B4B	5190373
D2582	Hi-Skid Step Leg Assembly	4 pcs (1 ea)	190-Large Fab - Steps - 3 - B4B	5176262
D2673-34	End Plate	4 pcs (1 ea)	190-Large Fab - Steps - 3 - B4B	5161432
MS20600-AD4W3	Cherry Rivet	64 Ea (16 ea)	190-Large Fab - Steps - 3 - B4B	5194356
AN3-37A	Bolt	8 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5161432
AN4-13A	Bolt	4 Ea (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5161432
AN4-16A	Bolt	8 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5161432
D2230-1	Mounting Lug	4 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5161432
D2230-3	Mounting Lug	4 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5161432
D2732-030	Rubber Cushion - 3"	8 pcs (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5161432
MS21042L3	Nut	8 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5161432
MS21042L4	Nut	12 Ea (3 ea)	280-Packaging 1-1 - Pick Kit - B4B	5161432
NAS1149D0363J	Washer	16 Ea (4 ea)	280-Packaging 1-1 - Pick Kit - B4B	5161432
NAS1149D0463J	Washer	24 Ea (6 ea)	280-Packaging 1-1 - Pick Kit - B4B	5161432

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2244-116	2	8	0
140-Large Fab - Steps - 2 - B4B	D2850-1	4	2	0
190-Large Fab - Steps - 3 - B4B	D2582	4	3	0
	D2673-34	4	69	0
	MS20600-AD4W3	64	340	0
280-Packaging 1-1 - Pick Kit - B4B	AN3-37A	8	57	0
	AN4-13A	4	430	0
	AN4-16A	8	671	0
	D2230-1	4	226	0
	D2230-3	4	815	0
	D2732-030	8	524	0
	MS21042L3	8	1,144	0
	MS21042L4	12	2,404	0
	NAS1149D0363J	16	1,569	0
	NAS1149D0463J	24	3,168	0

Part Specifications

Specifications could not be found.

Plex 6/26/19 4:20 PM Dart.Guerin.Kimberley

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5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
4	1	1	1	D2366-1	MOUNTING LUG
1	1	1	1	D2366-2	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-11A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT